Work Orde	er ID 76212		*762	712*					: ₍₁ - 1)	Page
Item ID: Revision ID:	D3199-1		Accept	*N900	040	100)* s	Setup Stai	17	S1*
Item Name:	Bracket							Sto	° *N	S2*
Required Date:	07/11/2011 Start Qty: 40.00 21/11/2011 Req'd Qty: 40.00		=	Cust Item I Customer:	D: .					~
Reference:						_	F	Run Stai	't *NI	D4*
Approvals:	Process Plan: M. L. J	Date: <u>\ </u>		. D	ate:			Sto	, 1/1	K i
	QC:	Date:	SPC (Y/N):	D:	ate:			50	´*N	R2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3199	Е									
100			0.00							
100 Waterjet FLOW CNC Waterjet 364. 646	FLOW WATER JET Memo ct Cut as per Dwg Rev: Prog Rev:		0.00				BI-	1- <u> 0</u>	(Ut)
	Deburr if	required							. •	

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

0.00

Memo Quality Control

1B11-11-10

Dart Aerosr	pace Ltd
-------------	----------

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
		Annual Control of the					Prod Mgr	, , , , , , , , , , , , , , , , , , , ,						
	<u> </u>							1						
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA :	Date: _							
	Resolution: Disposition: WORK ORDER NON-CONFORI					osed:	Date: _							
NCR:		,	WORK ORE	DER NON-CONFORMA	NCE (NCR	1)								
DATE	OTED	Description of NC		Corrective Action Secti		Verification	Approval	Approval						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector						
		•												
			,											

Work Order ID 76212 November-07-11 2:37:45 PM				*76212*						Page 2					
Item ID: Revision ID: Item Name: Start Date:	D3199-1 Bracket 07/11/2011	Start Qty: 40.00	*40*	Accept	*N900		I	Setu	p Start Stop	I VI	S1* S2*				
Required Date: Reference:		Req'd Qty: 40.00	*40*		Cust Item I Customer:	D:									
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:		Run	Start Stop	"[V]	R1* R2*				
Sequence ID/ Work Center II 120 *120 CQC Quality Control)	Operation Description QC8- Inspect parts - secon	nd check	Set Up/ Run Hours 0.00	Tool ID		Code Qt		•	Reject Number	Insp. Stamp				
*130 *130* Small Fab Small Fab		Small Fab Memo Form as per d	lwg D3199 use DT9723	0.00	Spulular		4	<u> </u>							
140 *140* QC		QC5- Inspect part complete	teness to step on W/O	0.00 0.00 U (u	122			wter 46		<u>. </u>					

Quality Control

W/O:			WORK ORDER CHANGES												
DATE	STEP	PRO	CEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
					·				-						
		PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	A:	Date:							
Resolution:			Disposition	·	_ QA: N/C C	losed:		Date:							
NCR:		V	WORK ORDER NON-CONFORMANCE (NCR)												
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	on B Sign		cation ion C	Approval Chief Eng	Approval QC Inspector						
		Section A	Chief Eng	Chief Eng	Date		ion C	Chief Eng	QC inspector						
		. 8													
		, we have			, , ,										
		•													
						·									
		·													

Work Order ID November-07-11 2:37:45		*762	717*				Page 3	
Item ID: D3199-1 Revision ID: Item Name: Bracket			Accept	*N900040	1100*	Setup	Start Stop	*NS1* *NS2*
Start Date: 07/11/20 Required Date: 21/11/20 Reference:	- -	*40* *40*		Cust Item ID: Customer:				
Approvals: Process QC:		Date:	Tooling: _ SPC (Y/N):	Date:			Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID 150 *150* Powdercoat Powder Coating 160 *160* QC Quality Control	Operation Description Grey Sandtex(Ref:4.3.5.6 Memo START TIM OVEN TEM FINISH TIM QC3- Inspect Part Finish Memo	E: 820 PERATURE: 36	Set Up/ Run Hours 0.00 0.00 0.00 0.00	Tool ID Tool #	Code Qty	Qty X	M-	leject Insp. Stamp
170 *170* Packaging Packaging	Identify as per dwg & Sto	ock Location:	0.00		(Fox)	€P		11-24.

W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					-		**************************************		1 Tod Wigi	,,,		
				,,	<u> </u>							
Part No	:	PAR #:	Fault Cate	egory:	_ NCR:	: Yes N	lo DQ	\ :	Date:			
	Re	esolution:	Disposition	on:	_ QA: I	N/C Clo	sed:		Date: _			
NCR:		,	WORK ORD	ER NON-CONFORMA	ANCE	(NCR)						
DATE	OTED	Description of NC	Description of NC Corrective Action Section					ation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector		
					İ							
		·										
· <u></u>												
	'					··· · · · · · · · · · · · · · · · · ·						

Work Order ID 76212 November-07-11 2:37:45 PM		*76212*						Page 4					
Item ID: Revision ID:	D3199-1 Bracket			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*	
Start Date: Required Date Reference:	07/11/2011	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:					IV.	.	
Approvals:	Process Pla	an:	Date:	Tooling: _ SPC (Y/N):		ate:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center	ID	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp	
180 QC Quality Control	,	Memo	ζ· , ε:	0.00					. , , 		111 0	798	
										Q(t	1129' (U)	9 U	

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CHAI	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
									1 Tod Wigi					
										<u> </u>				
					-									
Part No	•	PAR #:	jory:	! _ NCR: `	Yes N	lo DQ	A:	Date:						
	R	esolution:	Disposition	_ QA: N/	C Clo	sed:		Date:						
NCR:		1	WORK ORDE	R NON-CONFORMA	NCE (I	VCR)								
		Description of NC	Description of NC Corrective Action					ation	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng				Secti		Chief Eng	QC Inspector				
										·				
	1	1	1				i		l	I				

Picklist Print

November-07-11 2:37:49 PM

Work Order ID: 76212

76212

Parent Item:

D3199-1

D3199-1

Parent Item Name: Bracket

Start Date: 07/11/2011

Required Date: 21/11/2011

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:C IPP Rev:D

Removed Scribing 05-11-05 JLM

As per Rev B

06-11-24 JLM

IPP Rev:E

11.03.31 as per ecn 11-531 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	289.3795	0.099	4.168421			
1/1304520)GΔ								**	1/3/	-11-163		

304/316 .040 Sheet

Loca	ıtion	Loc Oty	Loc Code	
MAT	T020	289.3795		***
	116623	0.2		
٠.	117550	7.863		-
	117933	27.3442		
	118400	25.6723		
	118964	36.5		
	119346	191.8		119346



W/O:			WC	RES						
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
· · · · · · · · · · · · · · · · · · ·									FTGG WIGH	
								:		
Part No	· •	PAR #:	gory:	NCI	R: Yes I	No DQA	:	_ Date: _	1.00	
	Resolution: Disposition:						sed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)			
DATE	OTED	Description of NC			tion B		ation	Approval	Approval	
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng			Sign & Date	Section		Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	76212
Description: Bracket	Part Number:	D3199-1
Inspection Dwg: D3199 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

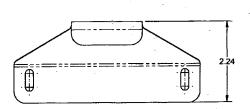
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.210	+0.005/-0.001	1313	>		V BUZ	
0.575	+/-0.010	,576	>		V	
1.090	+/-0.010	1.690	~		V	
2.015	+/-0.010	2.015	0		V	
2.971	+/-0.010	2,973	2		ν .	
1.830	+/-0.010	1.826	2		V	
4.830	+/-0.010	4.828	2		1	
4.030	+/-0.010	4.078	2.		V	
			-			
						·
·						*
						· .
		,				

Measured by: 🕟	Audited by: 👌	Preliminary Approval:
Date: - -	Date: Whalu	Date:

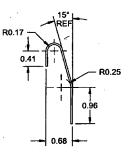
Rev	Date	Change	Revised by	Approved
Α	06.10.20	New Issue	KJ/JLM	
В	06.11.24	Dwg Revision revised	KJ/JLM LA	,,
С	11.03.08	Dwg Rev updated	KJ of	A)
	_			

1.500 R0.30 TYP BEND LINES R0.01 2.971 R0.105 4PL GRAIN DIRECTION 2.29 TYP 2.015 REF 1.00 1.090 REF 0.575 0.315 0.400 4.030 4.830

D3199-1F FLAT PATTERN









D

SHOP COBY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

W11-11-08

DESIG		gr	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
REV.		DE	ESCRIPTION BY DATE		
Α	NEW ISSUE			CP	03.08.05
В	2.24 WAS 2.142; ADD FINISH; UPDATE DWG			CB	06.11.01
C	ADD -3/-4 PART (SHEET 2-4)			HS	09.11.19
D	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF.: PAR11-79			мв	11.03.21
E	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO OPTIMIZE FIT.			мв	11.07.11

DRAWING NO. CHECKED REV. E D3199 MFG. APPR. SHEET 1 OF 4 TITLE APPROVED SCALE **BRACKET** DE APPR. COPYRIGHT © 2003 BY DARY AEROSPACE LTD DATE 11.07.11

NOTES:
1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
2) FINISH: PCOWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH

